

Work Order ID 50040

July 6, 2009 1:20:09 PM



Page 1

Item ID: D6202
Revision ID: A
Item Name: I-Beam Extrusion

Accept



Setup Start



Stop



Start Date: 07/06/2009 Start Qty: 20.00
Required Date: 07/08/2009 Req'd Qty: 20.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D6202	Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10030 (a) Description: American standard I-beam 4.000" x 2.796" x 0.326" thick (b) Material: 6061-T6/T651 (QQ-A-200/8) (c) Minimum ultimate tensile strength = 38 ksi (d) Minimum yield tensile strength = 35 ksi

CZ 09/07/08 20ft

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

Per 8/7/16 25 P100

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6202

=7 8 09/07/16

Work Order ID 50040

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Accept



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Required Date: 07/08/2009 Req'd Qty: 20.00



Cust Item ID:

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

07/07/28 (20)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

07/07/28

Picklist Print

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Page 1

Work Order ID: 50040

Parent Item: D6202RevA

Parent Item Name: I-Beam Extrusion



Comments:

Start Date: 07/06/2009

Required Date: 07/08/2009

Start Qty: 20.00

Required Qty: 20.00

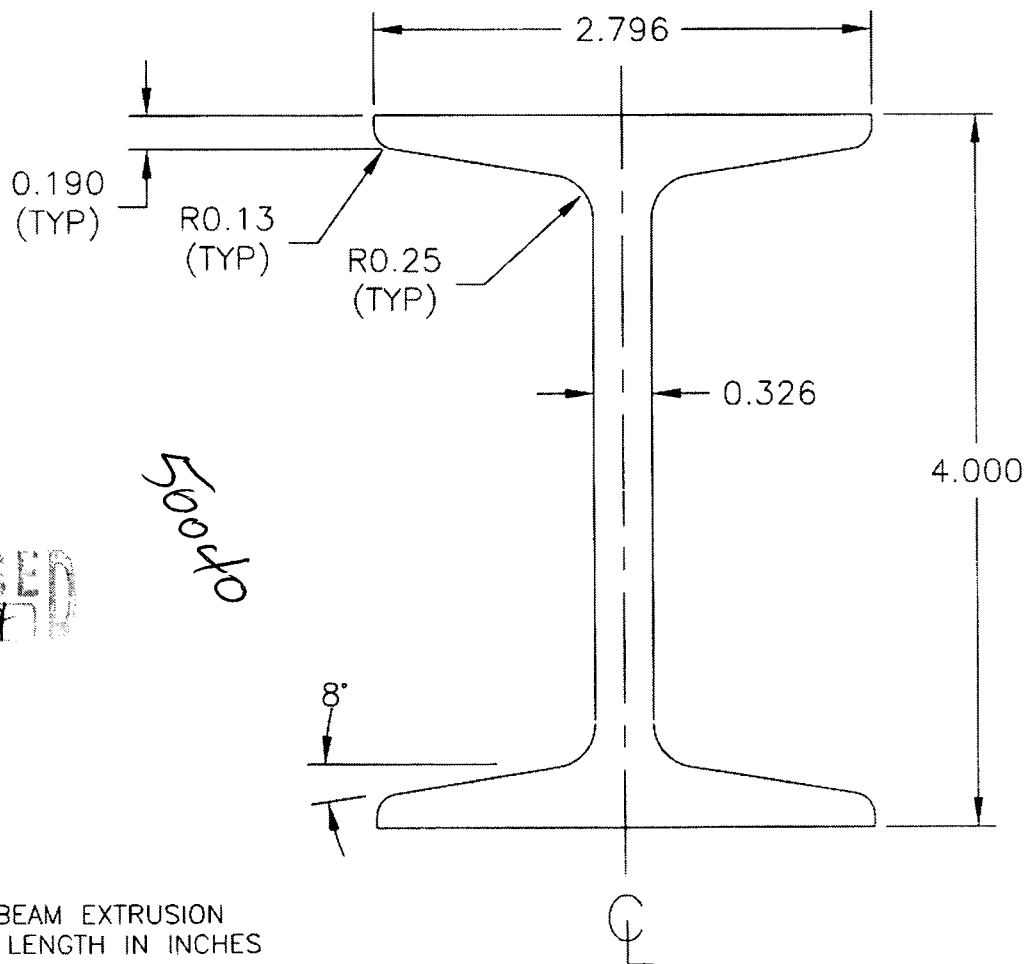
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6202PRevA		Purchased	No			110	f	0.0000	20.0000			
										<i>Rec'd 7/14</i>		
												
I Beam Extrusion												

U 9.07.17



DESIGN <i>JP</i>	DRAWN BY <i>LP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JP</i>	APPROVED <i>JP</i>	DRAWING NO. D6202	REV. A SHEET 1 OF 1
DATE 01.04.02		TITLE I-BEAM EXTRUSION	SCALE 1:1
A	01.04.02	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D6202-XXX I-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6202-027 IS 27 INCHES LONG

PURCHASE MATERIAL: AMERICAN STD. I-BEAM
4.000" x 2.796" x 0.326" THICK
6061-T6/T651 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I014419

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY , ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY , ON
K6A 1K7
Ship Terms: PREPAID



MTR:Y

SPECIAL INSTRUCTIONS

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	PO10030	
Sales Order	Terms		Ship Via	Date Ordered	Date Required	Date Shipped
W015570	NET 30 DAYS		NIR:R-557065-1	07/09/09	07/14/09	07/16/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	ALUMINUM - PCS 6061-T6 I-BEAM 4.00 X .326 X 25.1	1 PC L029408	200901097	1
Pieces: 1				Total Weight:		85 LB

Received by: _____ Date: _____ Signature: _____

P005898 - 200901094



SERVICE CENTER METALS
5850 Quality Way
Prince George, VA 23875

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS

OUR ORDER NUMBER	ITEM
902485	8

BILL TO

MANIFEST NUMBER

DIE NUMBER

DATE OF SHIPMENT

CERTIFICATION

SHIP TO

CUSTOMER PO

ALLOY / TEMPER

SALESPERSON

ASTM-B308 Stencil

P90209CG007 CT

6061-T6

David Schroeder

SPECIFICATION

ASTM-B221-08

CUSTOMER PART NUMBER

DESCRIPTION

SPECIFICATION

AMS-QQA-200/8

BS0291

ASI 4.000x2.796x.326

SPECIFICATION

AMS-QQA-200/16

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. SCM extrusions are manufactured in the USA from ingot melted and cast in the United States or Canada

Mechanical Properties

Lot No.	Test No.	Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation
200901097	1	02/27/09	47.9	46.2	13.9

Based on documentation furnished to us by the mill / supplier, we certify this material to be free of mercury contamination.

Scilicet

Chemical Composition for Alloy 6061

Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other: Each	Total	Al	Melted In
6061	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	Remainder	
	Min	0.40	0.15	-	0.8	0.04	-	-				

United States of America

DART

aerospace

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO10030

Purchase Order Date 7/08/09

PO Print Date 7/08/09

Page Number 1 of 1

Order From:

VC-MAG002

FAXED
613 632 1053

MAGNA STAINLESS
775 RUE KIERAN
ST LAURENT, QC H4S 0A3

Contact Name
Vendor Phone 800 363 6646
Vendor Fax 514 339 1105
Vendor Account Nbr

Buyer
Requisition Nbr
Tax Resale Nbr 6122-5207
Terms Net 30
Currency CAD
FOB

Sold To:

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7-
CANADA

Item Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	M304S18GA	304/316 .050 Sheet	7/08/09 Yes	✓ 160.00 sf	Yours ppd	\$5.0000	\$800.00
		Special Inst:	MATERIAL: AISI 304/316 SHEET ANNEALED 2B FINISH AS PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240				
	D6202P	I Beam Extrusion	7/08/09 Yes	20.00 f	Yours ppd	\$34.7500	\$695.00
		Special Inst:	DESCRIPTION: AMERICAN STANDARD I-BEAM SIZE: 4.000" X 1.796" X 0.326" THICK MATERIAL: 6061-T6 / T651 AS PER QQ-A-200/8 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI MINIMUM YIELD TENSILE STRENGTH = 35 KSI				
PO Total:							\$1,495.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 7/08/09